Work Order ID 61810

Packaging

Packaging

Page 1

Tuesday, September 07, 2010 12:40:52 PM

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Item ID: Revision ID:	D4101-041			Accept					Setup	Start		
	Pre-Flight Step	Assembly	15							Stop		
Start Date: Required Date:	9/7/2010 10/13/2010	Start Qty: 20.0 Req'd Qty: 20.0	00 u	4.	Cust Ite					,		
Reference:		,	· · · · · · · · · · · · · · · · · · ·	-								
Approvals:	Process Plan	n:	Date://2-9-07			Date:		J		Start Stop		
	QC:		Date:	SPC (Y/N):		Date:						
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool I	D Tool#	Plan Code	Accept Qty	Reje Qty		eject lumber	Insp. Stamp
Draw Nbr	Revi	sion Nbr			#		12					
D4101	В			•.			-	:				
				0.00				1	/	1.	7/1	
Small Fab		Memo		0.00				C/50	0		10	
Small Fab		1- Assen	nble as per dwg			,			·			
		QC5- Inspect part co.	mpleteness to step on W/O	0.00	.56	10/12/0) 9	15				
QC Quality Control		Memo		0.00		**		13)				
120		Identify as per dwg &	έ Stock Location: 237Α	0.00		, ,		10	/12	4	\mathcal{L}	158

0.00

Memo

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		WO	RK ORDER CHANGES	3								
STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
					·							
	•											
							<u></u>					
•	PAR #:											
Res	solution:	Disposition	:	QA: N/C	Closed:		Date: _					
	,	WORK ORDE	R NON-CONFORMAN	ICE (NC	R)							
CTED	Description of NC	Corrective Action Section B			Verifi	Verification	Approval	Approval				
SIEP	Section A	Initial Chief Eng	Action Description Chief Eng			tion C	Chief Eng	QC Inspector				
							3					
	STEP	STEP PRO PAR #: Resolution: Description of NC	STEP PROCEDURE CHAN PROCEDURE CHAN PAR #: Fault Category Resolution: Disposition WORK ORDE STEP Description of NC Section A Initial	STEP PROCEDURE CHANGE :PAR #: Fault Category: Resolution: Disposition: WORK ORDER NON-CONFORMAN STEP Description of NC Section A Section Section Section Section Part	PAR #: Fault Category: NCR: Yes Resolution: Disposition: QA: N/C C WORK ORDER NON-CONFORMANCE (NC STEP Description of NC Section A Initial Action Description Sign	WORK ORDER CHANGES STEP PROCEDURE CHANGE By Date PAR #: Fault Category: NCR: Yes No DQ Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	WORK ORDER CHANGES STEP PROCEDURE CHANGE By Date Qty :	WORK ORDER CHANGES STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr : PAR #: Fault Category: NCR: Yes No DQA: Date: Resolution: Disposition: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC				

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Page 2

Item ID:

D4101-041

Accept

Setup Start



Revision ID:

Item Name:

Pre-Flight Step Assembly

Start Date:

9/7/2010

Start Qty: 20.00

Req'd Qty: 20.00

Operation

Description



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start

Run

Stop



Required Date: 10/13/2010

QC: __

Date:

SPC (Y/N):

Set Up/

Run Hours

Date: ___

Stop



Sequence ID/

Work Center ID

130

Memo

QC21- Final Inspection - Work Order Release

0.00

0.00

Tool # Plan Accept Code Qty

Reject Qty

Reject Insp. Number

Stamp

Quality Control

W/O:			W	ORK ORDER CHANG	GES								
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No	•	PAR #:	_ PAR #: Fault Category: N				NCR: Yes No DQA: Date:						
	R	esolution:	n: Disposition: (Date: _				
NCR:			WORK ORI	DER NON-CONFORM	ANCE	(NCR)						
		Description of NC	Corrective Action Section B			Verification			Approval	Approvai			
DATE	STEP	Section A	Initial Chief Eng				Sign & Section C		Chief Eng	QC Inspector			
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Picklist Print

Tuesday, September 07, 2010 12:40:57 PM

Work Order ID: 61810

Parent Item: D4101-041

Parent Item Name: Pre-Flight Step Assembly



Start Date: 9/7/2010

Required Date: 10/13/2010

Start Qty: 20.00

Required Qty: 20.00

Comments:	IPP Rev:A 10.07.0	7 new issue DD	verf:Jl	LM									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310-4 NUT		Purchased	No			100	Each	32.0000		²⁹ / ₁₀	1/12/	69	
				Location		Loc	<u>Oty</u>	Loc Code		D	41159	36	
				ST324	115107		32 32		_		- M1	1607	- (D) (c)
VAN4-22		Purchased	No		113107	100	Each	9.0000	1 -	20	_ ///		
Bolt		T uronasou								3	10/12	69	
				Location ST359		Loc	9	Loc Code	_	· ·	M 11566 -	597	
D4101-1		Manufactured	No		115156	100_	9 Each	0.0000	1	 8	_		
Bracket		Manaractured					819	154		5	10/1-	2/0	9
D4101-3 Step		Manufactured	No			B6,	Each 1820	0.0000		20	500/1	2/0	29
D4101-5		Manufactured	No			100 [1	Each 36182	0.0000		$\frac{20}{20}$	10/1	2/0	9
Spring V MS24665-136		Purchased	No			100	Each	156.0000		20 25	000/	/ 2/6	/ የ
Cotter Pins				Location	1	Loc	Oty	Loc Code					
				ST309	-	<u> </u>	156		_				
					2421		156		_	15	_		· ·

W/O:			W	ORK ORDER CHANG	ES			·
DATE	STEP	PRC	OCEDURE CH	ANGE	Ву	Date Qt	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cat	egory:	_ NCR: Yes	No DQA:	Date: _	
	Res	PAR #: Fault Category: NCR: Yes No DQA: Date: Disposition: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR)					Date: _	
NCR:		•	WORK ORE	DER NON-CONFORM	ANCE (NCR			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Sect Action Description	ion B Sign 8	Verificatio Section C	n Approval Chief Eng	Approval QC inspector
		Section A	Chief Eng	Chief Eng	Date	Section C	Criter Eng	QC IIIspector
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Tuesday, September 07, 2010 12:40:57 PM

Work Order ID: 61810

Parent Item:

D4101-041

Parent Item Name: Pre-Flight Step Assembly



Start Date: 9/7/2010

Required Date: 10/13/2010

Start Qty: 20.00

455.0000

Required Qty: 20.00



Washer

Location	Loc Oty	Loc Code	
ST298	455		
110153	2		
114103	50		
114884	200		
115107	164		
13910	39		

NAS1149D0463J

Purchased

No

100 Each 792.0000

Each

I WI	•
- 1 3001/CD 00 1 1818/6 181 1809/ 1801 D/DIP 2011/6 10 1 00 1 0 01 0 01 0 108 1/1/2 0 1 1801	
/ BANICE: ABIJ BIB BIJ BIB BIJ B	

Washer

Loc Oty	Loc Code
672	
672	
120	
10	
24	
68	
. 18	
	672 672 120 10 24 68

Dart Aerospace Ltd W/O: WORK ORDER CHANGES DATE STEP PROCEDURE CHANGE By Date Qty Approval Chief Eng / Prod Mgr OC Inspector

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:	Disposition:	QA: N/C Closed:	Date:

NCR: WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B	Verification	Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	
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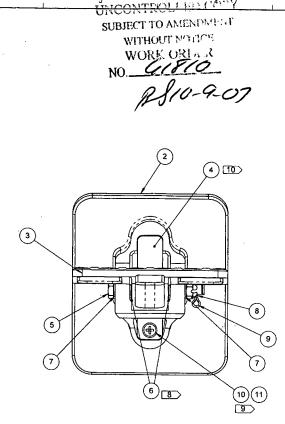
SHOP COPY

RETURN TO

ENGINEER RG

CONTROLL BLC4."Y

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	Х	D4101-041	PRE-FLIGHT STEP ASSEMBLY
2	1	D4101-1	BRACKET
3	1	D4101-3	STEP
4	1	D4101-5	SPRING
5	1	AN4-22	BOLT
6	2	NAS1149D0432J	WASHER
7	2	NAS1149D0463J	WASHER
8	1	AN310-4	NUT
9	1	MS24665-136	COTTER PIN
10	1	AN525-832R6	SCREW
11	1	MS21209C0815	HELICOIL



D4101-041 PRE-FLIGHT STEP ASSEMBLY

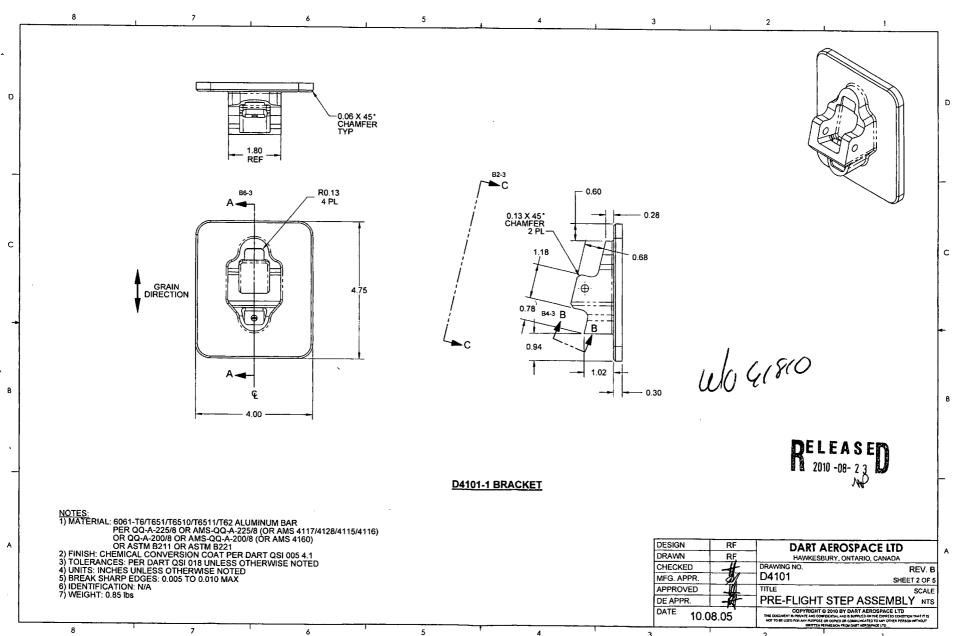
N	JIES:	
1)	MATERIAL: N/A	
	FINISH: NONE	
	TOLEDANIOED, F	

С

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: NONE
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4101-041" USING FINE POINT PERMANENT INK MARKER BACK SURFACE
7) WEIGHT: 1.18 lbs
8) INSTALL NAS1149D0432J WASHER IN BETWEEN STEP AND BRACKET MATING FACES
9) TORQUE AN525832R SCREW TO 15-25 in-lb
10) TEXTURED SIDE TO BOTTOM

В	NAS1149 SCREW D4101-5	D0432J WAS AND HELICOI (ZN B4-5)	RF	10.08.05			
A	NEW ISS	SUE	RF	10.07.12			
REV.			BY	DATE			
DESIG	V	RF	DART AEROSP	ACF	ĮD.		
DRAWN RF			HAWKESBURY, ONTARIO, CANADA				
CHECK	ŒD	-#	DRAWING NO.		REV. B		
MFG. A	PPR.	8/	↑D4101		SHEET 1 OF 5		
APPRO	VED		TITLE		SCALE		
DE APPR.			PRE-FLIGHT STEP ASSEMBLY NTS				
DATE 10.08.05			COPYRIGHT © 2010 BY DAR! THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS BUPP HOT TO BE USED FOR ANY PURPOSE OF COPED OR COMMUN. WRITTEN PRIVISION FROM DART	NEATED TO ANY OTH	S CONDITION THAT IT IS		

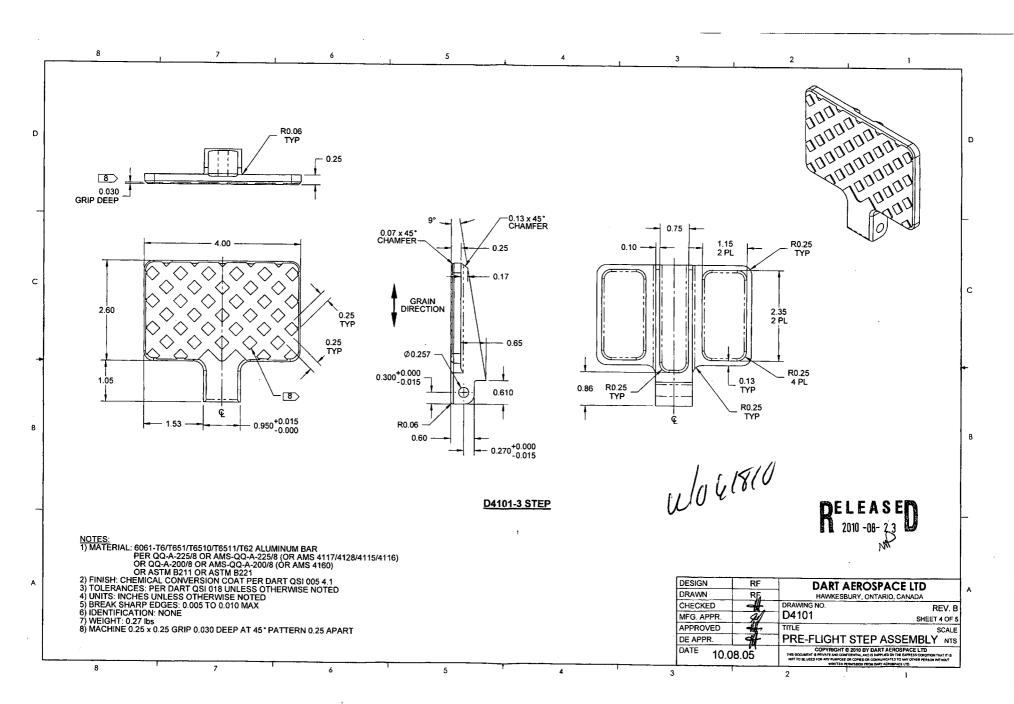
W/O:			W	ORK ORDER CHANGE	ES			
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:		PAR #:	Fault Cat	egory:	NCR: Yes	No DQA:	Date: _	
Resolution:			Dispositi	on:	QA: N/C Clo	sed:	Date: _	
NCR:			WORK ORE	DER NON-CONFORMA	NCE (NCR)		
DATE	CTED	Description of NC	Description of NC Corrective			Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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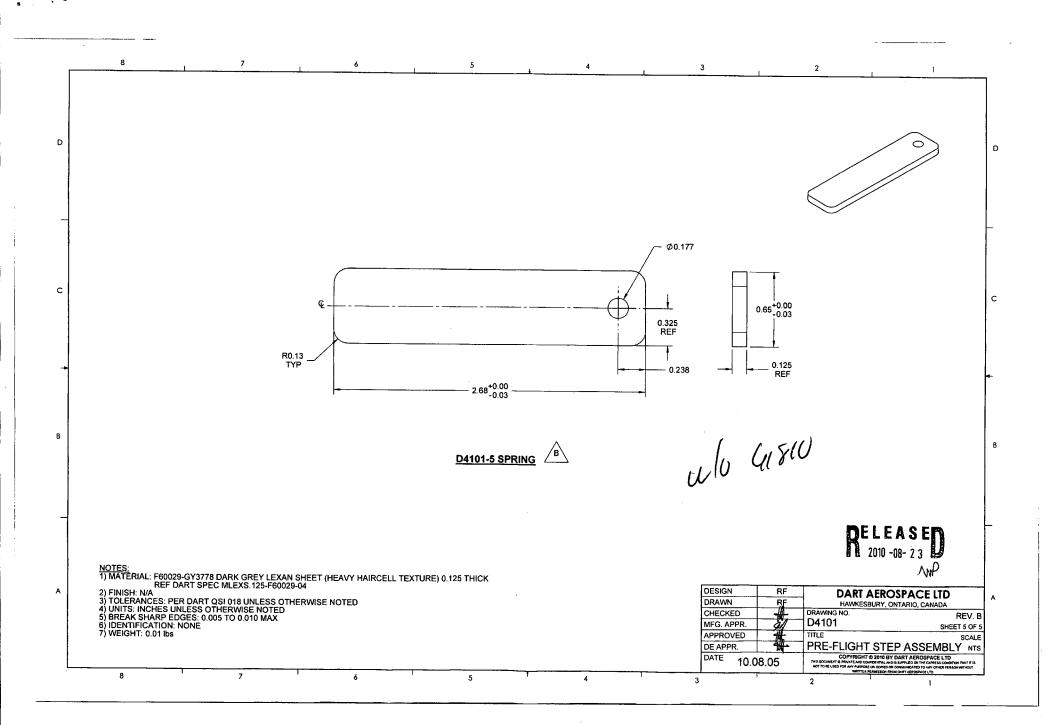
W/O:			W	ORK ORDER CHANG	ES								
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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NCR:			WORK ORD	ER NON-CONFORMA	ANCE (N	CR)		-					
		Description of NC Section A	Corrective Action Section B			Verific			Approval	Approval			
DATE	STEP		Initial Chief Eng	Action Description Chief Eng		gn & ate		on C	Chief Eng	QC Inspector			
							<u> </u>						

8 D D R0.25 2 PL R0.500 TYP 0.075 Ø0.257 2 PL 0.950 0.40 R0.13 0.350 8 PL 1.05+0.03 R0.06 TYP 0.850 С С 0.350 0.286 0.38 REF 1.35 0.400 0.255 R0.38 0.286 R0.06 TYP R0.13 4 PL 1.00 2 PL REF 4 PL DRILL & TAP FOR 8-32 HELICOIL Ø0.177 DRILL 0.40 DEEP & TAP 0.30 DEEP 0.51 0.670 0.30 REF 0.40 REF 2 PL SCALE 2X C7-2 VIEW B-B C4-2 SCALE 2X VIEW C-C D4-2 SCALE X1.5 Wo 41810 RELEASED 2010 -08- 23 DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN RF CHECKED DRAWING NO. REV. B D4101 MFG. APPR. SHEET 3 OF 5 TITLE APPROVED SCALE PRE-FLIGHT STEP ASSEMBLY NTS DE APPR. COPYRIGHT © 2010 BY DART AEROSPACE LTD
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W/O:			W	ORK ORDER CHANG	ES										
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NCR:			WORK OR	DER NON-CONFORM	ANCE (N	ICR)									
DATE	STEP	Description of NC	Corrective Action Section B			Verificatio			Approval	Approval					
DATE		Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Secti		Chief Eng	QC Inspector					
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Part No		PAR #:	Fault Cat	egory:	NCR: Yes	CR: Yes No DQA: Date:						
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NCR:		\	WORK ORE	DER NON-CONFORMA	NCE (NCF	₹)						
		STEP Description of NC Section A	Corrective Action Section B			Verific	cation	Approval	Approval			
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date	& Secti	Section C	Chief Eng	QC Inspector			
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Resolution:			Disposition: QA			A: N/C Closed: Date:					
NCR:			WORK ORD	ER NON-CONFORM	ANCE	(NCR)					
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